

Work Order ID 71844

Wednesday, July 13, 2011 10:21:11 AM

Page 1

Item ID: D4170-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Bushing

Start Date: 7/14/2011 Start Qty: 60.00

Cust Item ID:

Required Date: 7/28/2011 Req'd Qty: 60.00

Customer:

Reference:

Approvals:

Process Plan: MFDate: 11-07-13

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4170

B

0.00



Hardinge

Hardinge CNC LATHE SMALL

Memo

0.00

Hardinge CNC Lathe Small

Machine as per Folio FA962

SA 11/7/21

63 0

110



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

SA 11/7/21

63 0

120



QC

Quality Control

QC8- Inspect parts - second check

0.00

Memo

0.00

B.A 11/07/22

63 0

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Work Order ID 71844

Wednesday, July 13, 2011 10:21:11 AM

Page 2

Item ID: D4170-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Bushing

Start Date: 7/14/2011 Start Qty: 60.00

Cust Item ID:

Required Date: 7/28/2011 Req'd Qty: 60.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

125

0.00



Skidtubes

Memo

0.00

Skidtubes

1- clean crossbolt spacer with ultra bright aluminum cleaner before storing.

63 0 BE11/08/12

130

0.00



Packaging

Identify as per dwg & Stock Location LG

Memo

0.00

Packaging

STOCK IN SKIDTUBE CELL

63 0 BE11/08/12

140

0.00



QC

QC21- Final Inspection - Work Order Release

Memo

0.00

Quality Control

11/8/15

11-08-12
(63)

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
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NOTE: Date & initial all entries

Picklist Print

Wednesday, July 13, 2011 10:21:08 AM

Page 1

Work Order ID: 71844



Parent Item: D4170-1



Parent Item Name: Bushing

Start Date: 7/14/2011

Required Date: 7/28/2011

Start Qty: 60.00

Required Qty: 60.00

Comments: IPP REV:A NEW ISSUE 10-09-22 JLM VERIFIED BY:DD IPP
Rev:A 10.11.02 as per revB DD verf:EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

M6061T6T0.375W.058

Purchased

No

100

f

185.5480

0.2666

16.83789



11/7/21

6061-T6 RD Tube .375 x.058W

Location

Loc Qty

Loc Code

MAT014

185.548

115901

7.9

116920

0.578

117598

177.07

1828

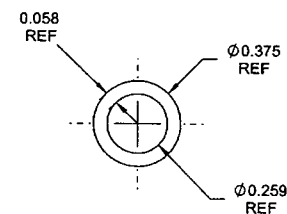
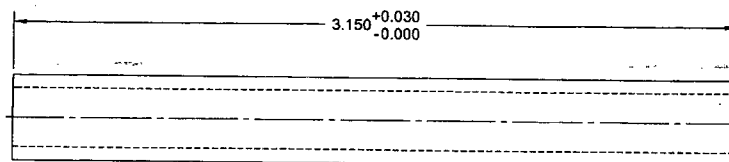
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NOTE: Date & initial all entries



D4170-1 SPACER

#71844

RELEASED
2010-11-01

NOTES:

- 1) MATERIAL: 6061-T6 OR 6061-T62 TUBING, $\phi 3/8$ OD X 0.058 WALL
PER WW-T-700/6, AMS 4080, AMS 4082, QQ-A-200/8, OR QQ-A-225/8
REF DART SPEC. M6061T6T0.375W.058
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01lbs

| | | | |
|------------|------------------|---|--------------|
| B | ADD -3 (SHEET 2) | CP | 10.10.25 |
| A | NEW ISSUE | SC | 10.07.22 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | SC | DART AEROSPACE USA, INC. | |
| DRAWN | JP | PORT HADLOCK, WA | |
| CHECKED | JP | DRAWING NO. | REV. B |
| MFG. APPR. | JP | D4170 | SHEET 1 OF 2 |
| APPROVED | JP | TITLE | SCALE |
| DE APPR. | JP | SPACER | NTS |
| DATE | 10.10.25 | <small>COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small> | |

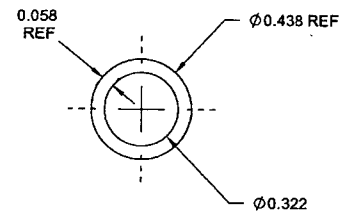
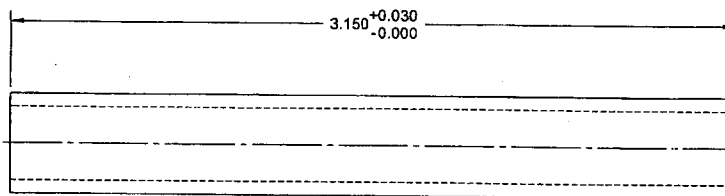
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NOTE: Date & initial all entries



D4170-3 SPACER

#71844

RELEASED
2010-11-01

NOTES:

- 1) MATERIAL: 6061-T6 ROUND BAR, $\phi 7/16$ OD
PER QQ-A-225/8, QQ-A-200/8, ASTM B211, OR ASTM B221
REF DART SPEC. M6061T6R0.438
OR
6061-T6 OR 6061-T62 TUBING, $\phi 7/16$ OD X 0.058 WALL
PER WW-T-700/8, AMS 4080, AMS 4082, QQ-A-200/8, OR QQ-A-225/8
REF DART SPEC. M6061T6T0.438W.058
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01lbs

| | | | |
|------------|-----------|---|--------------|
| DESIGN | SC | DART AEROSPACE USA, INC. | |
| DRAWN | <i>JP</i> | PORT HADLOCK, WA | |
| CHECKED | <i>JP</i> | DRAWING NO. | REV. B |
| MFG. APPR. | <i>JP</i> | D4170 | SHEET 2 OF 2 |
| APPROVED | <i>JP</i> | TITLE | SCALE |
| DE APPR. | <i>JP</i> | SPACER | NTS |
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